Work Order I. Thursday, May 20, 20												Page 1
Item ID: D35 Revision ID: Item Name: Door	94-5 Doubler		A	eccept					Setup	Start Stop		
		ty: 12.00 Pty: 12.00			Cust Item II Customer:	D:				-	î	1818
Approvals: Pro	cess Plan:		Date:	Tooling: SPC (Y/N):	·	ite:			Run	Start Stop		<b>i</b> iii
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr		100					~~	~ ~ ~			Stamp
D3594	Rev B											
Waterjet FLOW CNC Waterjet	FLOW WA	Memo 1-Cut as per I Deburr if neces		0.00 0.00 B □Prog Rev:	<b>8</b> <sub>□2-</sub>			1 <u>1</u>	0/05	5-7	7	(8)
110 QC Quality Control	QC2- Inspe	ect parts off ma	chine FAI/FAIB	0.00				(X	/ <u>- اه-</u>	<u>5 -</u> ?	7_	
120 	QC8- Inspe	ct parts - secon	d check	0.00	0105/31		(	×18	)			

Quality Control

	WORK ORDER CHANGES												
STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mar	Approval QC Inspector					
							1 Tod Wigi						
					·								
•	PAR #:	Fault Cate	egory:	NCR: Ye	s No <b>D</b> o	QA:	Date:						
Resolution:		Disposition	n:	QA: N/C	Closed: _		Date: _						
		WORK ORD	ER NON-CONFORM	IANCE (NO	R)								
STED	Description of NC				Veri	ication	Approval	Approval					
JIL!	Section A	Initial Chief Eng	Action Description Chief Eng		loc Se		Chief Eng	QC Inspector					
			***										
								5					
								].					
		:PAR #:	PAR #: Fault Cate  Resolution: Disposition  WORK ORD  STEP  Description of NC Section A  Initial	STEP PROCEDURE CHANGE  PAR #: Fault Category:  Resolution: Disposition:  WORK ORDER NON-CONFORM  STEP Description of NC Section A Corrective Action Se Initial Action Description	STEP PROCEDURE CHANGE By  PAR #: Fault Category: NCR: Yes  Resolution: Disposition: QA: N/C ON CONFORMANCE (NO WORK ORDER NON-CONFORMANCE (NO Section A Section A Initial Action Description Sign	STEP PROCEDURE CHANGE By Date  PAR #: Fault Category: NCR: Yes No DO Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty  PAR #: Fault Category: NCR: Yes No DQA:  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Section B Verification Section C Section C Section C Section C	STEP PROCEDURE CHANGE By Date Qty Chief Eng/Prod Mgr  :PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A					

	Work Order ID 58968  Chursday, May 20, 2010 12:36:11 PM												Page 2
	D3594-5  Door Doubler 5/20/2010 5/31/2010	Start Qty: 12.00 Req'd Qty: 12.00			ept	Cust Item I Customer:					Start Stop		
Approvals:	0.0	n:	Date:		ooling: C (Y/N):		ate:			Run	Start Stop	1 18611181 84	
Sequence ID/ Work Center II 130 Small Fab Small Fab		Operation Description Small Fab Memo	5 [PER dwg d3594	+	Set Up/ Run Hours 0.00	Draw Number	Draw Rev.	Plan Code	Accep	ot Rej Qty		Reject Number	Insp. Stamp
QC Quality Control		Мето			0.00	5/31			4/9	(E)			
150 HandFinish Hand Finishing		Chemical Conversion Coa	at per QS1005 4.1		0.00				MI		10	05	31 (8)

Ţ

W/O:			WC	ORK ORDER CHANG	ES			¥
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	·							
		·						
•								
Part No		PAR #:						
	R	esolution:					Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approvai
	-	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
					<u>.</u>			

Work Orde Thursday, May 2													Page 3
	D3594-5 Door Doubler			Acce	pt					Setup	Start Stop		
Start Date: Required Date: Reference:	5/20/2010 5/31/2010	Start Qty: 12.00 Req'd Qty: 12.00				t Item II tomer:	D:						
Approvals:		n:		1	oling: C (Y/N):		nte:		]	Run	Start Stop		
Sequence ID/ Work Center ID  160 QC Quality Control		Operation Description QC3- Inspect Part Finish Memo			Set Up/ Run Hours	raw Imber	Draw Rev.	Plan Code	Accept Qty	Qty	]	Reject Number	Insp. Stamp
170    <b>                                  </b>		Identify as per dwg & Stoc  Memo	k Location: 234		00 100				_\v-\	,	(	130	<del>-</del>
180  QC  Quality Control		QC21- Final Inspection - W	Vork Order Release		00					Pl	10	10/0E	601 A)

W/O:			WC	WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
							Frod Wigi						
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQA</b> : _	Date: _						
		esolution:											
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR	)							
DATE	CTED	Description of NC	Description of NC Corrective Action				n Annroyal	Ammanual					
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector					
	,												
		-											
	1							].					

**Picklist Print** Page 1 Thursday, May 20, 2010 12:36:16 PM Work Order ID: 58968 Parent Item: D3594-5 Parent Item Name: Door Doubler Start Date: 5/20/2010 Required Date: 5/31/2010 IPP Rev : A New Issue 08.07.07 Comments: EC verified by DD Start Qty: 12.00 Required Qty: 12.00 Component Item ID/ Replacement Mfg/ Primary Last Route Unit of Qty on Qty per Kit Qty Date Status **Item Name** Item ID Purch Item Location Location Seq ID Measure Hand Issued Issued M6061T6S.080 Purchased No 100 (2 sf 161.2419 0.055 1810-5-27 6061-T6 .080 Sheet

 Location
 Loc Oty
 Loc Code

 MAT21
 161.24193

 113438
 2.7512

 114351
 158.49073

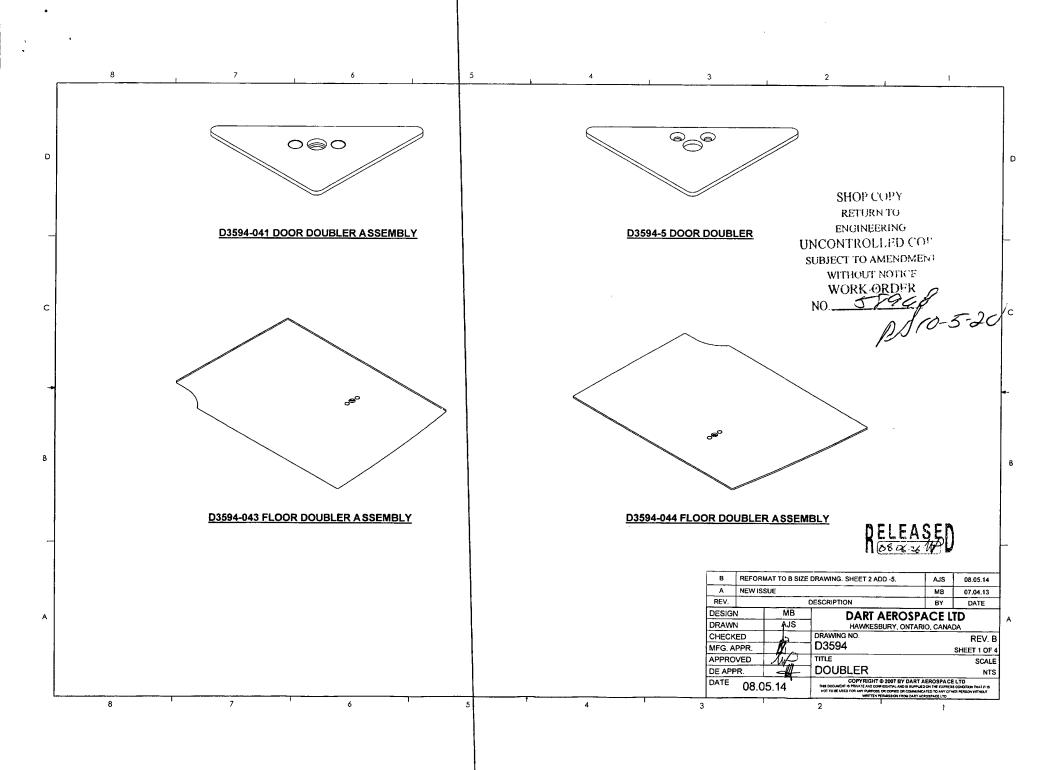
W/O:		WORK ORDER CHANGES												
DATE	STEP	PR	OCEDURE CH	ANGE	:	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
					:									
							·							
Part No	:	PAR #:	Fault Cate	egory:	NCR:	Yes	Vo DQ	٨:	Date:					
	Re	esolution:	Disposition	on:	QA: N	/C Cld	sed:		Date:					
NCR:		,	WORK ORDER NON-CONFORMANCE (NCR)  Corrective Action Section B											
DATE	STEP Description of NC			Section B		Verific	ation	Approval	Approval					
		Section A	Initial Chief Eng	Action Description	on	Sign & Date	Section		Chief Eng	QC Inspector				
							<u> </u>							
										•				

DART AEROSPACE LTD	Work Order:	58968
Description: Door Doubler	Part Number:	D3594-5
Inspection Dwg: D3594 Rev: B		Page 1 of 1

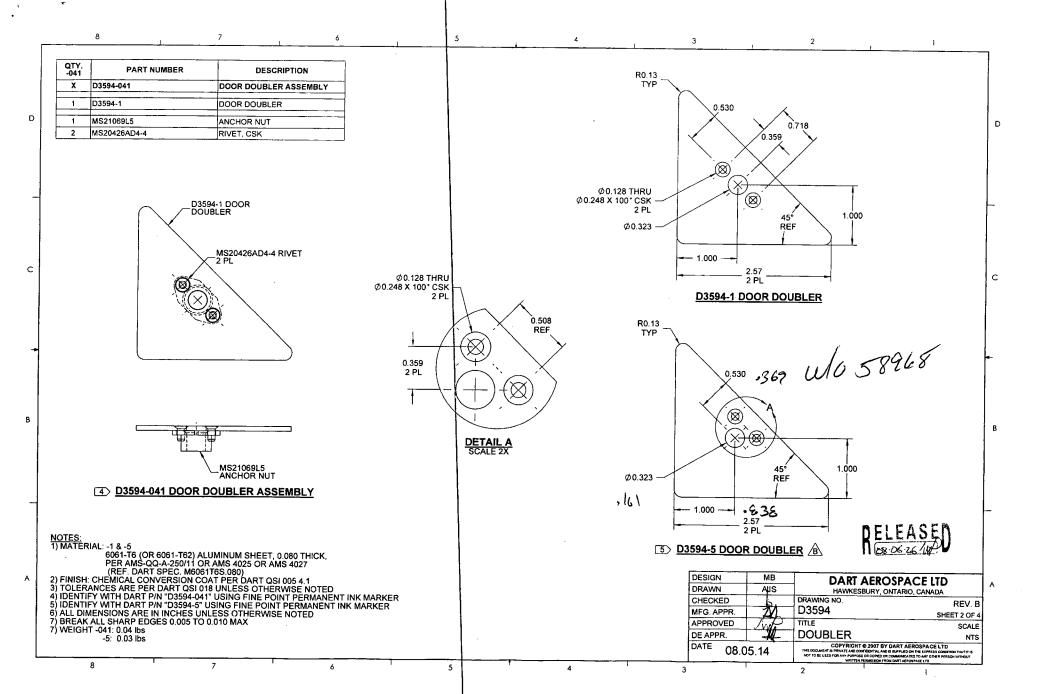
		X First Ar	ticle	Prote	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.323	+0.006/-0.001	.385	*			
Ø0.128	+0.005/-0.001	.132	*			
2.57	+/-0.030	2,570	<b>&gt;</b>			
1.000	+/-0.010	1.000	8			
1.000	+/-0.010	1.000	*	-		
0.530	+/-0.010	. \$30	<b>%</b>			
R0.13	+/-0.030	113	Ø			
				<del></del>		
						***
	1 111					
		<u> </u>				
easured by:	B	Audited by:	12		Prototype Approv	al: N/A
Date:	10-5-57	Date:	$+ \circ$	<del></del>	Da	

	Date:	10-5-27	Date: 10(0,13)	Date:	N/A
Rev	Date	Change		Revised by	Approved
Α	08.07.24	New Issue		KJ/DD 🚓	13/

W/O:			WC	RK ORDER CHANG	ES			,
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty Approv Chief Eng Prod Mg	g/ Approvar
Dort No.		<b></b>						
Part No		PAR #:						
	Res	olution:					Date	•
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCI	⊀)		
DATE	STEP	<b>Description of NC</b>		Corrective Action Section		Verificat	ion Approv	al Approval
		Section A	Initial Chief Eng	Action Description  Chief Eng	Sign Date		C Chief En	g QC Inspector
							:	
							ļ	
-								



W/O:		WORK ORDER CHANGES												
DATE	STEP	PR	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
						į.								
						:								
			· - · - · · · · · · · · · · · · · · · ·											
Part No	:	PAR #:	Fault Ca	tegory:	NCF	R: Yes	No DQA	<u> </u>	_ Date: _					
		esolution:												
NCR:			WORK OR	DER NON-CONFORM	MANCE	(NCR	)							
DATE	STEP	Description of NC Section A	Initial	Corrective Action Se Action Description	ection B	Sign &	Verific		Approval Chief Eng	Approval				
		Jection A	Chief Eng	Chief Eng		Date	Sectio	n C	Chief Eng	QC Inspector				
										_				
					·									
					;									
								į						



W/O:			W	ORK ORDER CHANG	ES					
DATE STEP		PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		-								
Part No:		PAR #:	Fault Cate	egory:	NCR: Yes No DQA: Date:					
	Re	esolution:	Disposition	on:	QA: N/C Clo	osed: Date:				
NCR:		1	WORK ORE	ER NON-CONFORMA	NCE (NCR	2)	72.			
DATE	STEP	Description of NC Section A		Corrective Action Section		Verification	Approval Chief Eng	Approval QC Inspector		
			Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Section C				
				•						
						İ				
							<u> </u>			
	1				ŀ	1	1			

8 5 3 2 QTY. -043 QTY. -044 PART NUMBER DESCRIPTION X D3594-043 FLOOR DOUBLER ASSEMBLY, LH х D3594-044 FLOOR DOUBLER ASSEMBLY, RH 1 D3594-3 FLOOR DOUBLER, LH D3594-4 FLOOR DOUBLER, RH WO 58968 MS21069L5 ANCHOR NUT 2 2 MS20426AD4-4 RIVET, CSK MS21069L5 ANCHOR NUT -MS21069L5 ANCHOR NUT MS20426AD4-4 MS20426AD4-4 -RIVET 2 PL RIVET 2 PL . 1 . \* -D3594-3 FLOOR DOUBLER D3594-4 FLOOR DOUBLER **D3594-043 FLOOR DOUBLER ASSEMBLY** D3594-044 FLOOR DOUBLER ASSEMBLY NOTES:
1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART PIN "03594-043/-044" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) WEIGHT -043 & -044-01 80 INS DESIGN MB DART AEROSPACE LTD DRAWN AJSI HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3594 MFG. APPR. SHEET 3 OF 4 APPROVED TITLE SCALE **DOUBLER** DE APPR. NTS 7) WEIGHT -043 & -044: 0.80 lbs COPYRIGHT 6 2007 BY DART AEROSPACE LTD
THIS DOCUMENT IS PROVIDE AND COMPOSITION OF COMPUTED TO ANY OTHER PROPERTY OF COMPUTED TO ANY OTHER PRINCIPS ON COMPUTED TO ANY OTHER PRINCIPS OF THE DART OTHER PRINCIPS ON THE DATE OF COMPUTED TO ANY OTHER PRINCIPS ON PRINCIPS DATE OF COMPUTED TO DATE 08.05.14

8

7

D

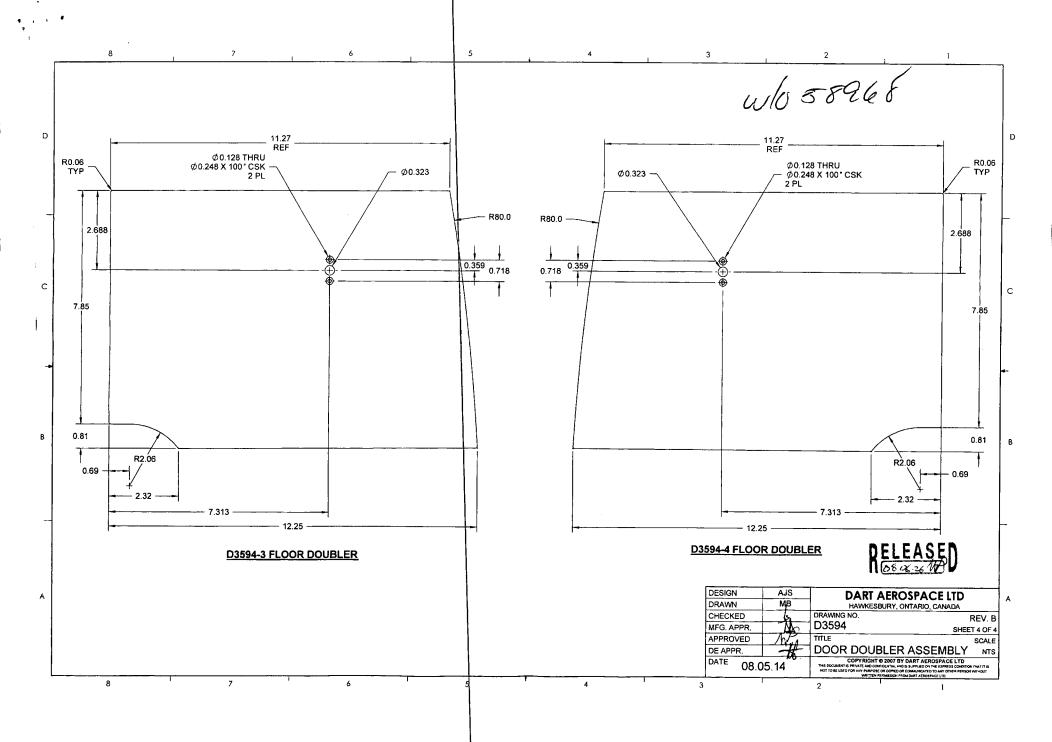
С

3

D

С

DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr QC In	spector
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:	
Resolution: Disposition: QA: N/C Closed: Date:	
NCR: WORK ORDER NON-CONFORMANCE (NCR)	
DATE STEP Description of NC Corrective Action Section B Verification Approval App	Approval QC Inspector



W/O:			W	ORK ORDER CHANG	ES				đ
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						10.00	,		
						*	,		
Part No		PAR #:	Fault Category:		NCR: Yes No DQA:			Date:	
	Res	solution:	ution: Disposition:			closed:			
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description		on B		Verification	Approval	Approval
			Chief Eng	Chief Eng	Date		Section C	Chief Eng	QC Inspector
								-	